

**Work Order ID 53434**

November 04, 2009 10:37:37 AM

Page 1

Item ID: D3953-5

Revision ID: A

Item Name: Gas Spring Stud, Base

Start Date: 11/5/2009 Start Qty: 10.00

Required Date: 11/17/2009 Req'd Qty: 10.00

Reference:

Accept

Setup Start

Stop

Cust Item ID:

Customer:

Approvals:

Process Plan: mfDate: 09-11-04

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr

Revision Nbr

D3953

A

0.00

0.00

0.00

0.00

100



Doosan

Doosan Lathe

Memo

Turn as per folio FA853 &amp; DWG

FOLIO REV: AADWG REV: A

DEBURR

110



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

09.11.0509.11.0520 φ20 φ

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

November 04, 2009 10:37:36 AM

Page 1

Work Order ID: 53434



Parent Item: D3953-5



Parent Item Name: Gas Spring Stud, Base



Start Date: 11/5/2009

Required Date: 11/17/2009

Comments: IPP RevA: New issue 09.10.14 DD verified by:EC

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304R1.750 		Purchased	No			100	f	9.4600	1.3158 			
304 ROUND BAR 1.750												

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

9.46

112939

9.46

2.66

*AP 09.11.05*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 53434
<b>Description:</b> GAS SPRING STUD, BASE		<b>Part Number:</b> D3953-5
<b>Inspection Dwg:</b>	<b>Rev:</b>	Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

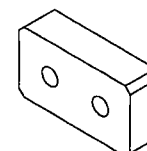
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
.813	+/- .010	.813	/			
.194 <del>Ø</del>	+1.004 - .001	.196	/			
.75	+/- .030	.752	/			
.375	+/- .010	.375	/			
.38	+/- .030	.390	/			
.875	+/- .010	.875	/			
1.63	+/- .030	1.631	/			
1/4-28 UNF 2A <del>.2665</del>	<del>.2665</del>	.265	/			
R.06	+/- .030	R.062	/			
.098 <del>Ø</del>	+1.004 - .001	.100	/			
.250	+/- .010	.250	/			
.170	+/- .010	.170	/			
.330	+/- .010	.330	/			
.13	+/- .030	.132	/			
1.44	+/- .030	1.442	/			

<b>Measured by:</b> <i>[Signature]</i>	<b>Audited by:</b> <i>[Signature]</i>	<b>Prototype Approval:</b> N/A
<b>Date:</b> 09.11.05	<b>Date:</b> 09/11/09	<b>Date:</b> N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	



### D3953-9 GAS SPRING WASHER



**D3953-17 GAS SPRING SPACER**  
(SPLIT LID)

RELEASED  
2009-10-08

A	NEW ISSUE		AJS	09.07.27
REV.		DESCRIPTION	BY	DATE
DESIGN	AJS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA  DRAWING NO. <b>D3953</b>  TITLE <b>GAS SPRING LID COMPONENTS</b>	REV. A	
DRAWN	AJS		SHEET 1 OF 4	
CHECKED	<i>B</i>			
MFG. APPR.	<i>E</i>			
APPROVED	<i>NO</i>			
DE APPR.	<i>[Signature]</i>			
DATE	09.07.27	COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS RETURNED TO THE SUPPLIER CONSIDERING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE WRITTEN AND SIGNED APPROVAL FROM DART AEROSPACE LTD.		



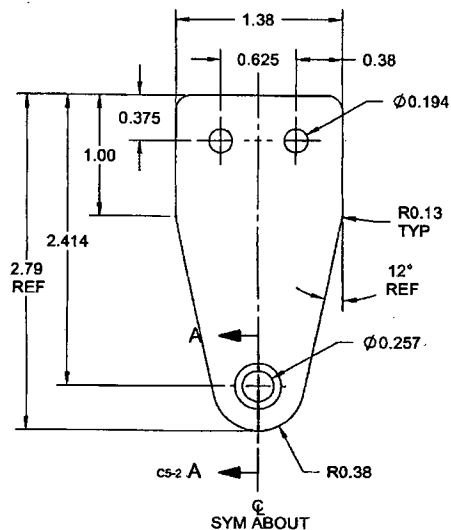
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

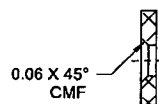
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

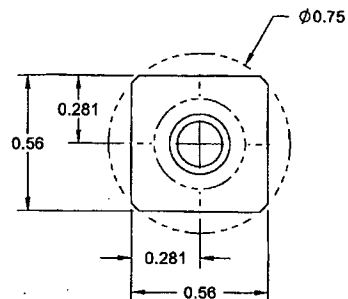
**NOTE:** Date & initial all entries



**D3953-1 GAS SPRING BRACKET**  
(FULL LID)

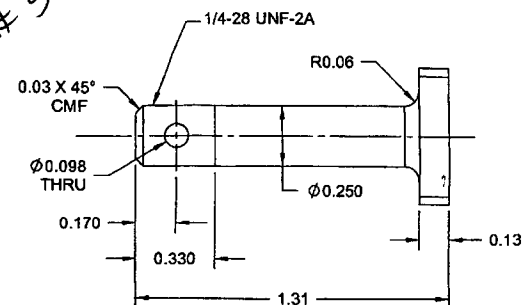


**SECTION A-A** C7-2

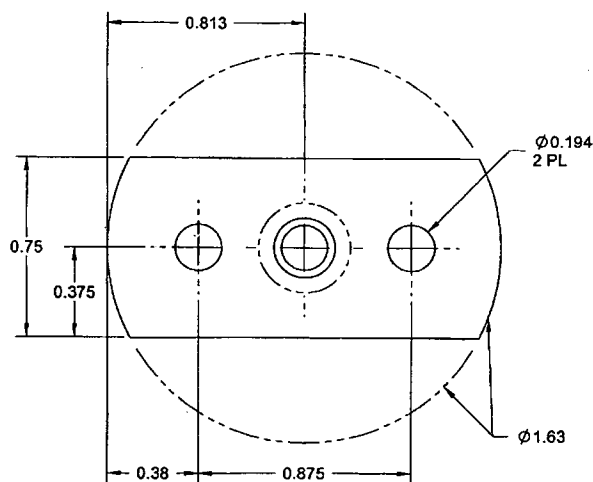


**D3953-3 GAS SPRING STUD, LID**

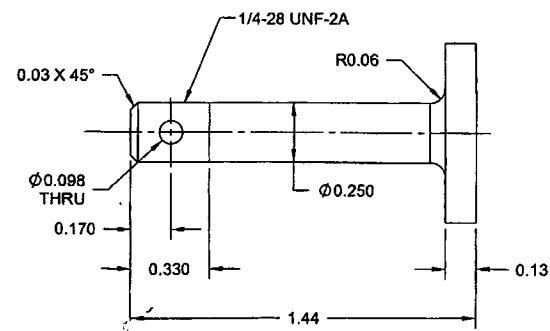
#53434



**RELEASED**  
2009-10-08



**D3953-5 GAS SPRING STUD, BASE**



**NOTES:**

1) MATERIAL -1: MATERIAL: AISI 304 STAINLESS STEEL SHEET, 0.125 THICK  
REF DART SPEC M304S

-3 & -5: AISI 304 STAINLESS STEEL BAR  
REF DART SPEC M304B

OR: AISI 304/316 STAINLESS STEEL ROD  
REF DART SPEC M304R

2) FINISH: N/A

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3953-X" USING FINE POINT PERMANENT INK MARKER

7) WEIGHT -1: 0.11 lbs  
-3: 0.03 lbs  
-5: 0.06 lbs

DESIGN	AJS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	[Signature]	DRAWING NO.	REV. A
MFG. APPR.	[Signature]	<b>D3953</b>	SHEET 2 OF 4
APPROVED	[Signature]	TITLE	SCALE
DE APPR.	[Signature]	<b>GAS SPRING LID COMPONENTS</b>	NTS
DATE	09.07.27	<small>COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries